

Ship this wk 2/23/02

Work Order ID 66626

Wednesday, February 23, 2011 9:20:21 AM

Page 1

Item ID: D3199-4

Revision ID:

Item Name: Bracket, Fwd RH

Start Date: 2/23/2011 Start Qty: 1.00

Required Date: 2/23/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3199

901

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: PPI

Prog Rev: PPI

Deburr if required

1B11-2-23

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1B11-2-23

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Item ID: D3199-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket, Fwd RH

Start Date: 2/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	-inspected to PD1 Dm only 8/11/02/23						
130 Brake NC Brake NC	Bend as per dwg Small Fab Memo	0.00 0.00	SB 11/02/24	①					
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	-inspected to PD1 Dm only 8/11/02/25	④					

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3199-4 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-02-25 11-02-25	130	scrap extra part only made for head punch	LC 11-02-25		SRB 11-02-25		LC 11-02-25	

NOTE: Date & initial all entries

Work Order ID 66626

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Item ID: D3199-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket, Fwd RH

Start Date: 2/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____*N/A*

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____ 0.00

Memo

*Exempt for test fit**P. 4/2/10 ①**Re*

Work Order ID 66626

Wednesday, February 23, 2011 9:20:21 AM

Page 4

Item ID: D3199-4

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket, Fwd RH

Start Date: 2/23/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/23/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 2/23/11 AUTH

RELEASED _____ DATE _____

U110225
EN41106

Picklist Print

Page 1

Wednesday, February 23, 2011 9:20:19 AM

Work Order ID: 66626



Parent Item: D3199-4



Parent Item Name: Bracket, Fwd RH

Start Date: 2/23/2011

Required Date: 2/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: RevC-prelim DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	111.0938	0.3371	0.354842			



304/316 .040 Sheet



11-2-23

Location

Loc Qty

Loc Code

MAT

111.0938

115953

21.6

116437

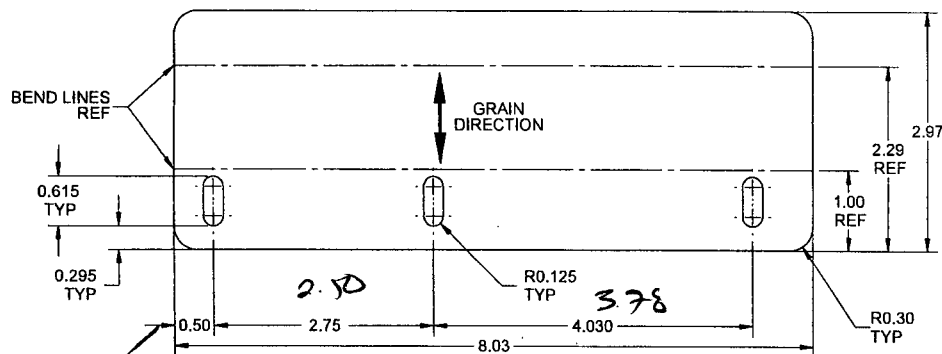
52.2538

116623

37.24

116623

5



PD1 **D3199-3F FLAT PATTERN**

W/O 66626

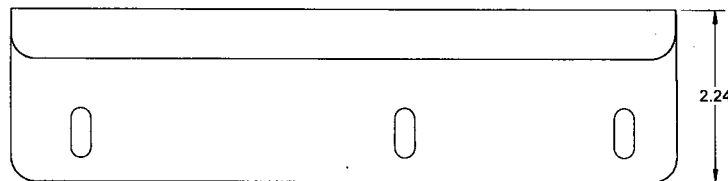
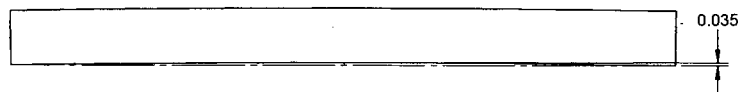
PRELIMINARY ISSUE

11.02.18

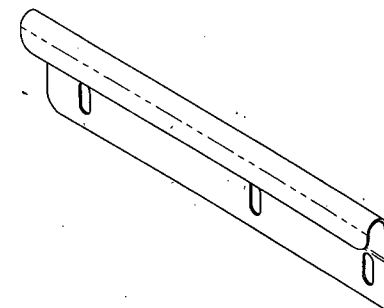
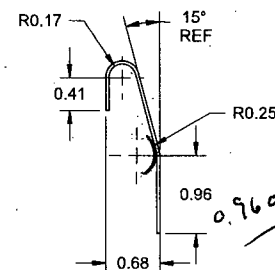
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PD1
MFG. APPR.		D3199	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.02.18	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3199-4 BRACKET
MADE FROM D3199-3F



NOTES:

- 1) MATERIAL: MADE FROM D3199-3F
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-4" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

DESIGN		DART AEROSPACE LTD	
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PRELIMINARY ISSUE

11.02.18

11.02.18

Linda Lacelle

From: Marc Bellavance <mbellavance@dartaero.com>
Sent: February 22, 2011 2:50 PM
To: Lacelle, Linda; Duval, David
Cc: Petsche, Mike; Shepherd, David; Fauteux, Melanie
Subject: D412-698-027/-028/-037/-038

Importance: High

Linda/David,

I have loaded PDF copies of D3199 and D3675 both at revision PD1 here.
Affected DXF's (D3199-3F and D3675-5F) can also be found there.

Please have qty(1)kit -027/-037 made and shipped to Calgary (attention David and/or Harvey?). Not sure if -028/-038 are required.

Would be great if we could get those kits shipped to Eagle before end of this week for trial fit since they have an aircraft equipped with composite doors at their disposition.

Thanks!

Marc Bellavance
Technical/Shop Support

DART aerospace Ltd.

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E-mail: mbellavance@dartaero.com

Web: www.dartaero.com

Product Documentation: Verify Revision Status/Download HERE!



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